

Date: Monday, 17/07/2006 1:32:45 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B SCUFF PLATE, FWD LH
Job Number : 27932	
Estimate Number : 12263	
P.O. Number : N/A	Part Number : D206555001
This Issue : 17/07/2006 S.O. No. : N/A	Drawing Number : D206-555 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : 82
Previous Run : N/A	Material : N/A
Type : PURCHASED PARTS	Due Date : 24/07/2006
Written By : _____	Qty: 10 Um: Each
Checked & Approved By : _____	
Comment : Est. C 99.06.29 Returned to Electro Polish DM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Type Labels as per PPP D206-555-001

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 208

Email or ship DXF file to vendor

Laser cut part as per DXF file

Material release note required

3.0	D206555001F	Scuff Plate Fwd LH 206B
-----	-------------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit - Total : 10.0000 Each(s)

Scuff Plate Fwd LH 206B

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

5.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Date: Monday, 17/07/2006 1:47:43 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B SCUFF PLATE, FWD LH

Job Number: 27932

Part Number: D206555001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT 8314-1

FF 06-10-03

Finish form on bench forming Jig DT 8315-1

SB 06/07/18

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting Outside services

Issue P/O: 2181

Electro Polish

C Loc 110104 (11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

06/10/16 (11)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST139

06/10/04 (11)  
06/10/18 (11)

P/O  
See  
attached  
7

Date: Monday, 17/07/2006 1:47:44 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B SCUFF PLATE, FWD LH

Job Number: 27932

Part Number: D206555001

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

11  
D 06/10/20

Job Completion



u do 10.19

FW



**NORTH AMERICAN  
STAINLESS**

# METALLURGICAL TEST REPORT

6870 Highway 42 East  
Ghent, KY 41045-9615  
(502) 347-6000

Certificate: 290000 02

Mail To:  
WILKINSON STEEL AND METALS  
ATTN: MILL CERTIFICATE SCANNER  
888 SOUTHEAST MARINE DRIVE  
VANCOUVER, BC V5X2V3  
CANADA

Ship To:  
WILKINSON STEEL AND METALS  
888 SOUTHEAST MARINE DRIVE  
VANCOUVER, BC V5X2V3  
CANADA

Date: 11/22/2005 Page: 1

Steel: 304

Finish: 2B

Your Order: P51013PC004

NAS Order: AE 0329272 02

Corrosion: ASTM A262/02aE; 180Bend-OK

## PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/04a, 480/04a, 666/03, ASMESA240/04, SA480/04, SA666/04  
Q8766D-A X NG PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

## REMARKS:

Material free from mercury contamination. No weld repairs.  
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A

06.04.05

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
B40627	* 0679E9 A	.0240	48.0000	2,475 SHEET	120.00	2	65
B40628	* 0679E9 A	.0240	48.0000	2,485 SHEET	120.00	3	65

## CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
79E9	.057	18.152	.369	1.666	.319	.046	8.205	.029	.001	.326

## MECHANICAL PROPERTIES

Product ID #	Coil #	Id o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Tail Hard	Hard R45T
B40627	0679E9	F T	97.09	48.19	48.98	49.00	46.50
B40628	0679E9	F T	97.09	48.19	48.98	49.00	46.50

QC ENGINEER

ERIC HESS

11/22/2005

215WD007-1 T M INDUSTRIAL (P51013PC004-79E9)

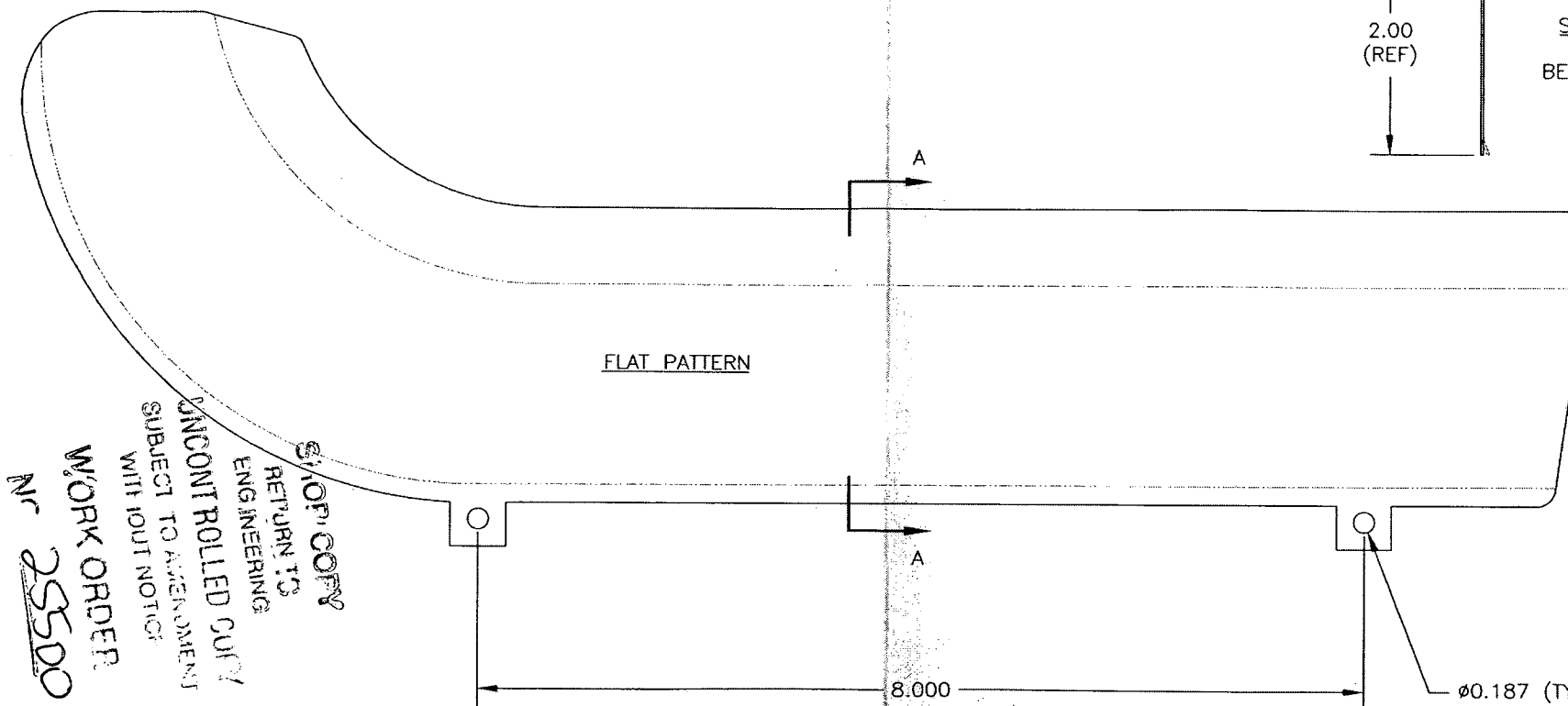


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. 8 SHEET 1 OF 7
DATE 98.10.26		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	

RELEASED  
99.01.11 KE

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMEND  
WITHOUT NOT  
WORK ORDER  
NO. 25500



5/01/00 COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
N<sup>o</sup> 25500

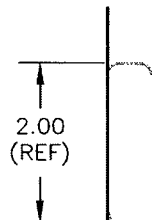
D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)  
D206-555-002 (BEND OPPOSITE)

BEND PER M/F TEMPLATE D206-555-T1  
MATERIAL: AISI 304/316 0.020 THICK  
FINISH: BRIGHT COLD ROLLED (2B)  
NO SCRATCHES ON SURFACES

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
99.01.11 KE

DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD WARRICKBURY, OXFORD, CANADA	
CHECKED JA	APPROVED	DRAWING NO. D206-555	REV. B SHEET 2 OF 7
DATE 98.10.26		TITLE DOOR SILL SCUFF PLATES	SCALE 1:1



SECTION C-C  
DETAIL OF  
BENDING SHOWN

DETAIL B  
SCALE 1:1

REFER TO DETAIL B  
FOR 1:1 SCALE

16.000 (REF)

FLAT PATTERN

8.000

8.000

Ø0.187 (TYP 3 PLACES)

D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)  
D206-555-004 (BEND OPPOSITE)

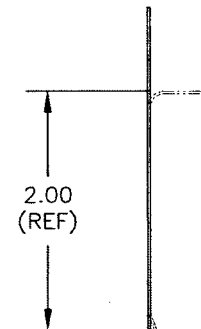
BEND PER M/F TEMPLATE D206-555-T3  
MATERIAL: AISI 304/316 0.020 THICK  
FINISH: BRIGHT COLD ROLLED (2B)  
NO SCRATCHES ON SURFACES

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

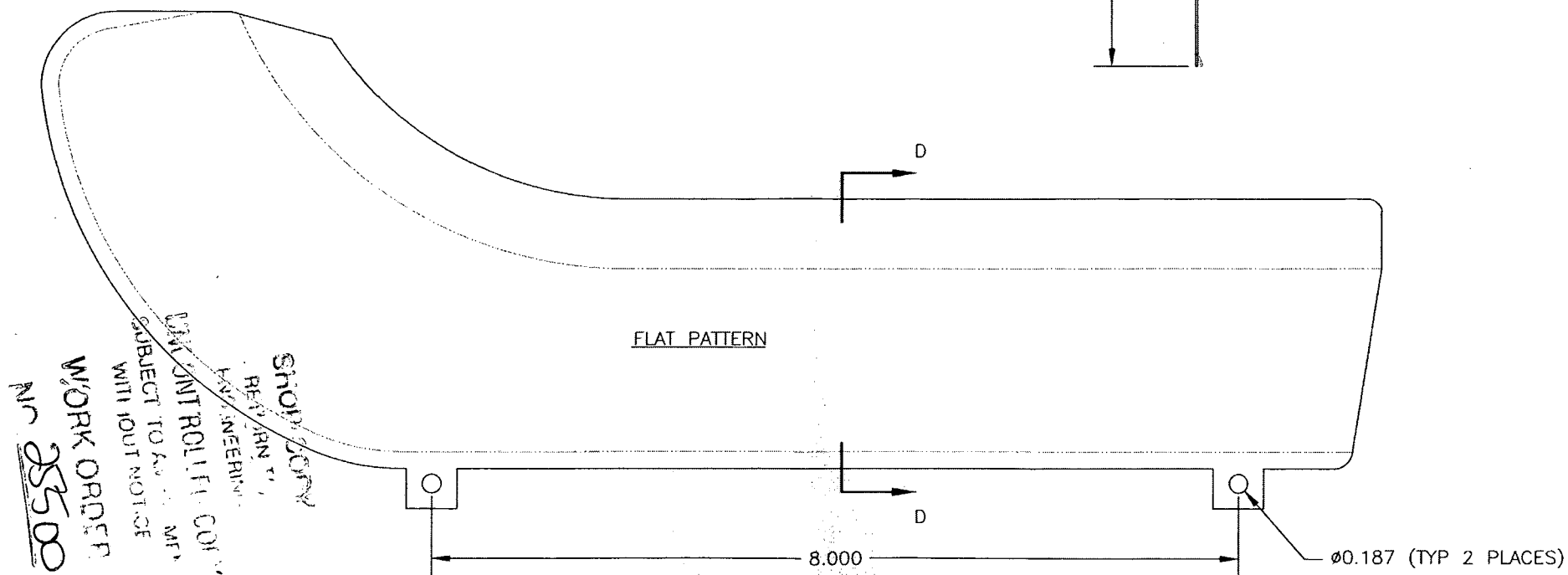
RELEASED  
99.01.11 KE



DESIGN 	DRAWN BY 	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D206-555
DATE 98.10.26	TITLE DOOR SILL SCUFF PLATES	REV. B SHEET 3 OF 7 SCALE 2:3



SECTION D-D  
DETAIL OF  
BENDING SHOWN



SHOP COPY  
REVISION  
ENGINEERING  
UNION ROLL CO.  
SUBJECT TO A.M.T.  
WITH OUT NOTICE  
WORK ORDER  
NR 25500

D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)  
D206-555-006 (BEND OPPOSITE)

BEND PER M/F TEMPLATE D206-555-T5  
MATERIAL: AISI 304/316 0.020 THICK  
FINISH: BRIGHT COLD ROLLED (2B)  
NO SCRATCHES ON SURFACES

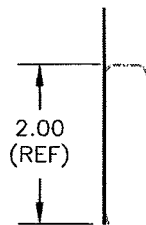
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
99.01.11 KE



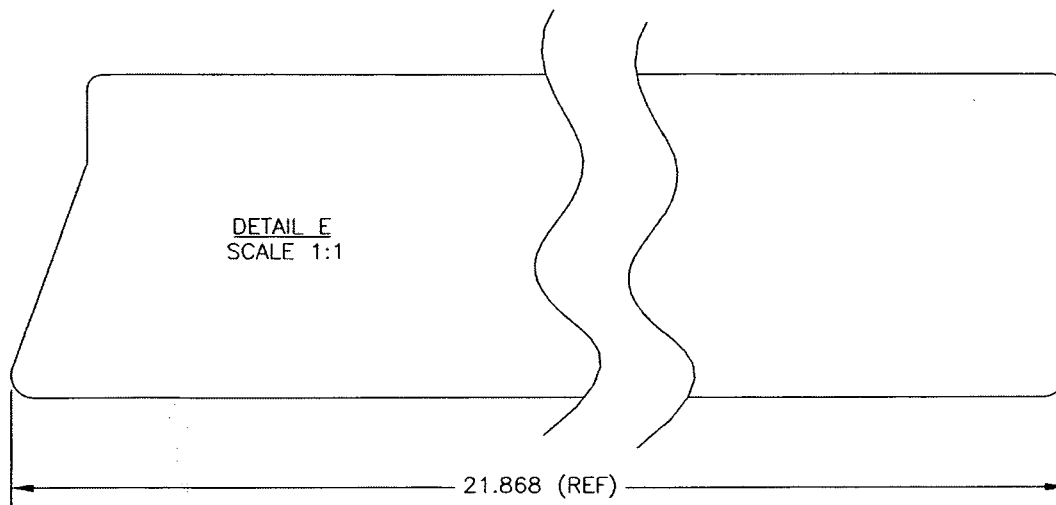
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD MISSISSAUGA, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D206-555
DATE 98.10.26	TITLE DOOR SILL SCUFF PLATES	REV. B SHEET 4 OF 7 SCALE 1:1



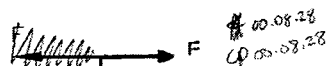


SECTION F-F  
DETAIL OF  
BENDING SHOWN

DETAIL E  
SCALE 1:1



REFER TO DETAIL E  
FOR 1:1 SCALE



FLAT PATTERN



D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

BEND PER M/F TEMPLATE D206-555-T7  
MATERIAL: AISI 304/316 0.020 THICK  
FINISH: BRIGHT COLD ROLLED (2B)  
NO SCRATCHES ON SURFACES

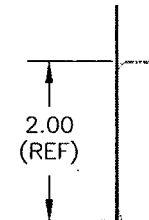
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
99.01.11 KE



DESIGN 	DRAWN BY 	<b>DART</b> DART AEROSPACE LTD HAWESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D206-555	REV. B SHEET 5 OF 7
DATE 98.10.26		TITLE DOOR SILL SCUFF PLATES SCALE 2:3	

10.25500  
WORK ORDER  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
RETURN TO  
ENGINE AREA  
GROUP OFFICE



SECTION H-H  
DETAIL OF  
BENDING SHOWN

REFER TO DETAIL G  
FOR 1:1 SCALE

DETAIL G  
SCALE 1:1

16.000 (REF)

*Handwritten:* H  $\frac{1}{16} \pm 0.0078$   
 $\phi \pm 0.0028$

FLAT PATTERN

RELEASED  
*Handwritten:* 09.01.11 KE

8.000

8.000

$\phi 0.187$  (TYP 3 PLACES)

D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

BEND PER M/F TEMPLATE D206-555-T9

MATERIAL: AISI 304/316 0.020 THICK

FINISH: BRIGHT COLD ROLLED (2B)

NO SCRATCHES ON SURFACES

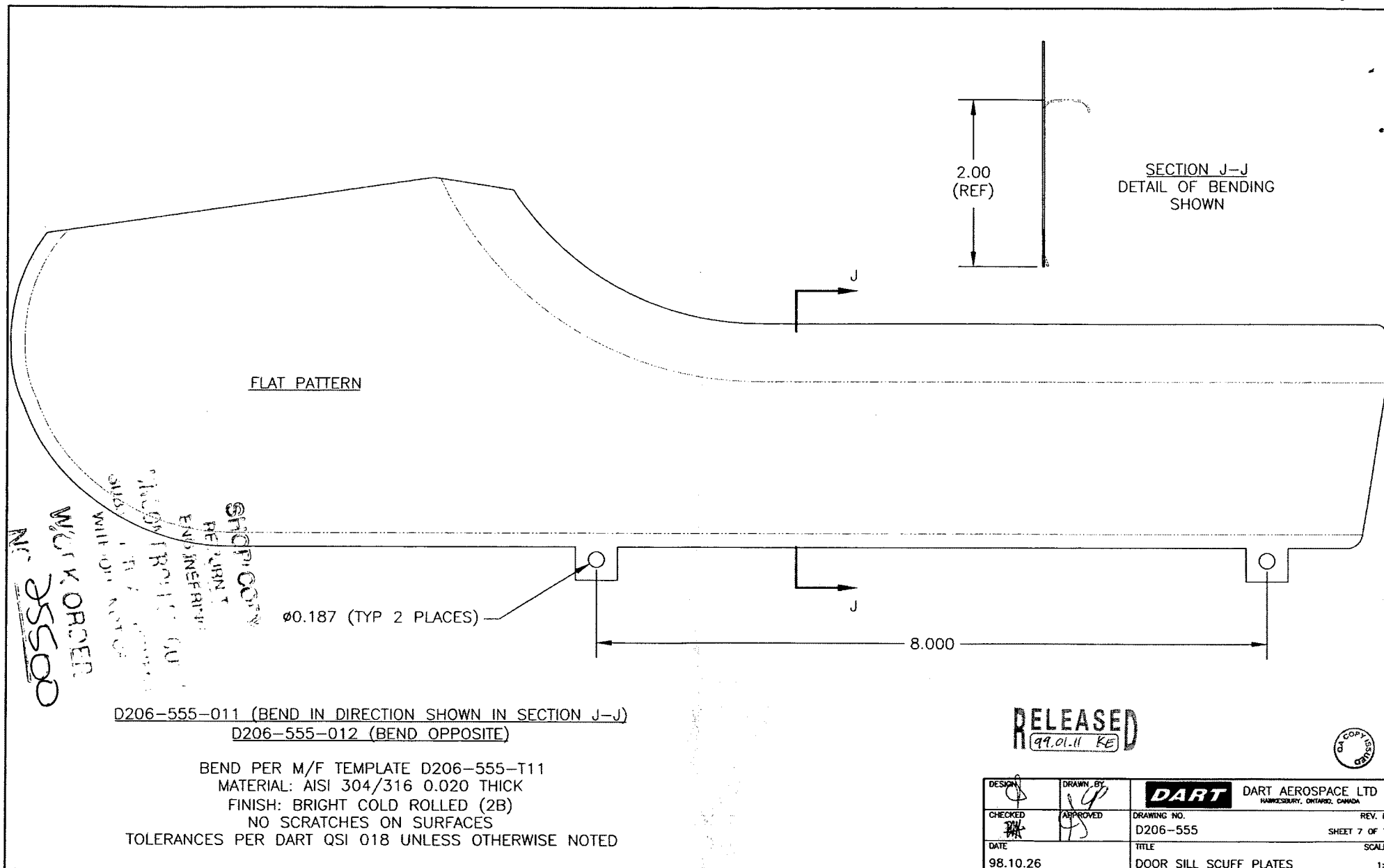
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN <i>Handwritten:</i> [Signature]	DRAWN BY <i>Handwritten:</i> [Signature]	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED <i>Handwritten:</i> [Signature]	APPROVED <i>Handwritten:</i> [Signature]	DRAWING NO. D206-555
DATE 98.10.26	TITLE DOOR SILL SCUFF PLATES	REV. B SHEET 6 OF 7 SCALE 2:3

Copyright 1989 by DART AEROSPACE LTD

*Handwritten:* 1025500

*Handwritten:* SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROL ROOM





## Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: October 12, 2006

1270 Aberdeen St  
Hawkesbury, Ontario  
K6A 1K7

tel.: (613) 632-9577 fax: (613) 632-1053

No. de certificat  
Certification No.

**C108535**

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
119118		NO. DE COM./P.O.# 2181	ELECTROPOLISH PER ASTM B912 REV.02 ✓
	11	D206-555-002	
	11	D206-555-001	
	10	D206-555-007	
	10	D206-555-009	

*Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et specifications et sont en accord avec les exigences ci-inclus.*

*We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.*

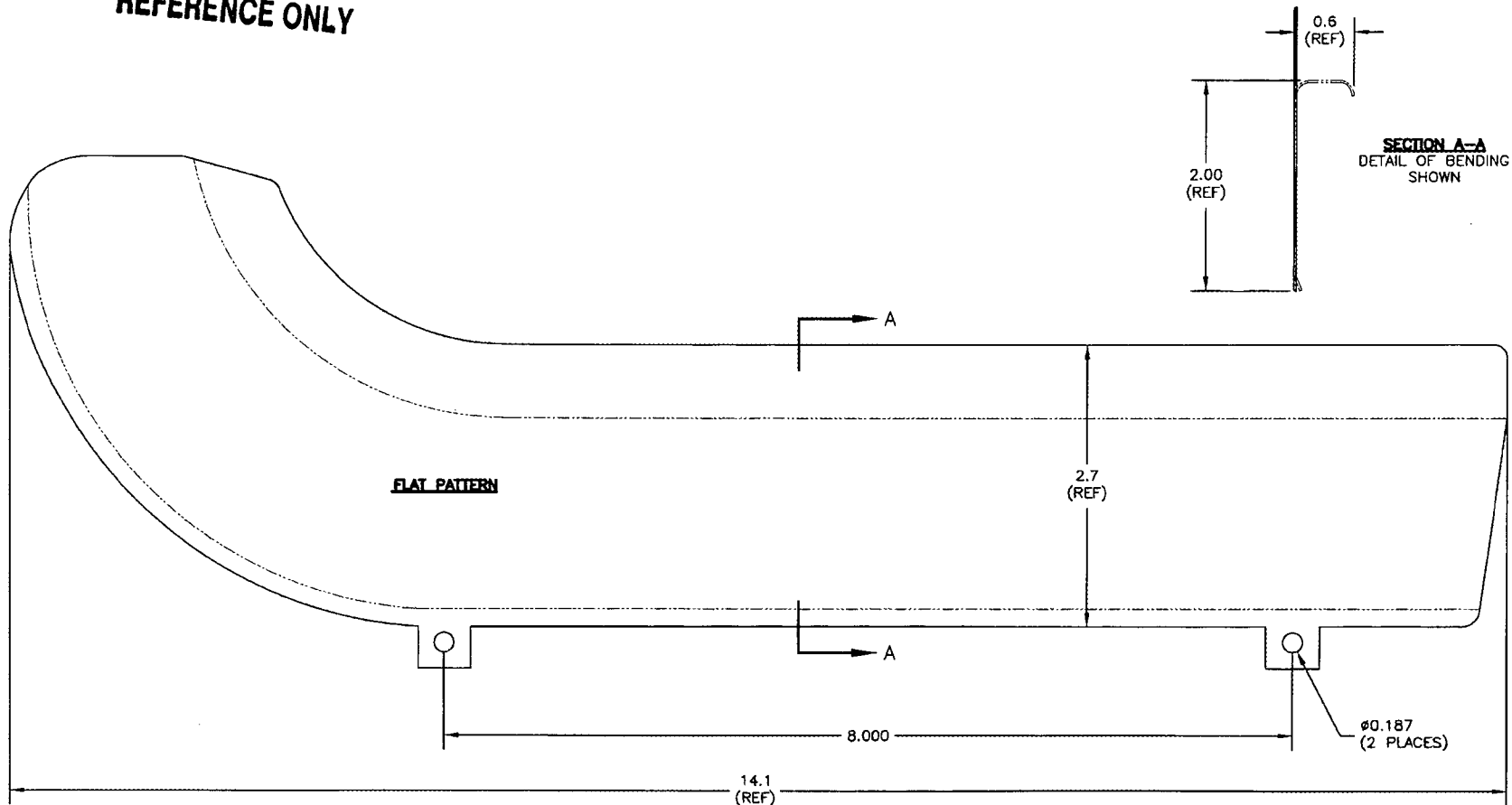
Signé pour et au nom de TQF Technologies Inc.  
Signed for and on behalf of TQF Technologies Inc.

*Ry*

Raj Thakoordeen

Total Quality Finishing

REFERENCE ONLY



RELEASED

06-09-19

D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)  
D206-555-002 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S256A)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	JB	DRAWN BY	B	<b>DART</b>	DART AEROSPACE LTD	REV. C
CHECKED	PH	APPROVED	PH	DRAWING NO.	D206-555	SHEET 2 OF 7
DATE	06.09.01	TITLE	DOOR SILL SCUFF PLATES	SCALE	1:1	

Purchase Order Number  
P000002181

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**FXED**  
2006/10/09

**Vendor Address:**

T.Q.F. Technologies  
6640 Vanden Abeele  
St-Laurent, QC H4S 1Y3  
Canada  
Phone (514) 333-3895  
Fax (514) 333-8576

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-TQF001	Oct 04, 2006	N30	Fedex	Oct 18, 2006

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
11.0000	D206555002 B25499	SCUFF PLATE Comments: ELECTRO CHEMICALLY POLISH PER ASTM B912 HIGH SHINE NO SCRATCHES ON SURFACE PLEASE RETURN VIA PUROLATOR COLLECT ACCT: # 7684382	10/18/2006	No	12.600000		138.60
11.0000	D206555001 B27932	SCUFF PLATE Comments: AS ABOVE	10/18/2006	No	12.600000		138.60
10.0000	D206555007 B26228	SCUFF PLATE Comments: AS ABOVE	10/18/2006	No	12.600000		126.00
10.0000	D206555009 B26229	SCUFF PLATE Comments: AS ABOVE	10/18/2006	No	12.600000		126.00

**CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY**

**REFERENCE ONLY**

Comments: <b>REFERENCE ONLY</b>  Entered By: <i>CZ</i> CLAVOIE Approved By: <i>[Signature]</i>	Tax Summary: GST 31.75 GSTME 0.00 GSTND 0.00	Less: included tax 0.00 Subtotal 529.20 Total tax 31.75 Total purchase order in CAD Dollars 560.95

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-10-18	11.	Tabs to be removed a Step 6. Perm change <i>[Signature]</i>					<i>[Signature]</i> 06-10-18

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/16/20  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries